



METALOCK DTM HIGH BUILD PRIMER

TECHNICAL DATA SHEET



Check local VOC regulations to ensure compliance of all products in your area.

DESCRIPTION

Metalock™ DTM High Build Primer is a two component epoxy primer for use on metal, aluminum, SMC and fiberglass.

FEATURES

- Superior adhesion
- Outstanding corrosion protection
- Exceptional filling properties
- High build formula
- Sealer mixing option
- Easy to sand

SUITABLE SUBSTRATES

- Steel
- Aluminum
- Plastic
- SMC
- Fiberglass
- OEM finish
- Primer

TYPICAL PROPERTIES

Part:	Product Name:	Color:	Container:
ML010	Metalock DTM High Build Primer Kit	Gray	Kit
ML014	Metalock DTM High Build Primer	Gray	Quart
MLH16	Metalock Hardener	Clear to Amber	Half Pint
RTS weight solids:		60%	
RTS volume solids:		40.5%	
Regulatory VOC (ML014):		0.63 #/gl (76 g/l)	
Actual VOC (ML014):		0.32 #/gl (38 g/l)	
Regulatory VOC (MLH16):		5.45 #/gl (654 g/l)	
Actual VOC (MLH16):		4.47 #/gl (536 g/l)	
Regulatory VOC MIXED:		2.01 #/gl (242 g/l)	
Actual VOC MIXED:		1.15 #/gl (138 g/l)	



Check local VOC regulations to ensure compliance of all products in your area.

Pot life:	@ 70°F (21°C) and 50% R.H. 12 hours
Coverage at 2 mils:	325 sq.ft./gal

Use VOC calculator to determine VOC of mixtures. Check local VOC regulations to ensure compliance of all products in your area.

HANDLING AND APPLICATION

PREPARATION:

STEEL AND ALUMINUM:

Clean with **SEM Solve** or **XXX Universal Surface Cleaner**. Apply to 180 grit sanded or sandblasted steel or aluminum. If rust or corrosion is present, grind or sandblast until all rust and corrosion have been removed. Blow off and clean again with **SEM Solve** or **XXX Universal Surface Cleaner**.

SMC AND FIBERGLASS:

First, clean with **Plastic & Leather Prep** or **XXX Universal Surface Cleaner**. Next, sand with 180 grit sand paper. Blow off dust and re-clean with **Plastic & Leather Prep** or **XXX Universal Surface Cleaner**. Blow off again to ensure the surface is completely dry. Do not saturate exposed fibers.

Note:

When using **Metallock** as a sealer, sand the surface with 320 grit sandpaper or finer.

MIXING:

For best results, use at approximately 70°F (21°C).

Thoroughly mix **Metallock DTM High Build Primer** and **Metallock Hardener** before use.

AS A HIGH BUILD PRIMER, MIX BY VOLUME:

4 Parts	1 Part
Metallock DTM High Build Primer	Metallock Hardener

AS A PRIMER SEALER, MIX BY VOLUME:

4 Part	1 Part	1 Part
Metallock DTM High Build Primer	Metallock Hardener	High quality urethane reducer

Metallock is ready to spray once mixed and does not require an induction period.

Note:

Metallock Hardener may appear yellow or darken over time. This is normal and will not affect the product's performance.



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APPLICATION:

Product Name:	Fluid Tip	Coats	Flash Time between
High Build Primer	1.7-2.0	2 Medium	10-15 minutes
Primer Sealer	1.3-1.5	1 Medium	10-15 minutes

Air Pressure:	6-9 psi at the cap with HVLP equipment
	25-45 psi for non HVLP equipment

Time to Apply Body Filler:	24 hours
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Allow a minimum of 2 hours dry time before sanding. Allow a minimum of 1 hour before top-coating. Dry times may vary depending on film build and shop conditions.

If waiting longer than 24 hours to recoat, **Metalock** must be sanded with 180 grit or finer sand paper.

CLEANUP:

Use appropriate cleaning materials compliant with VOC regulations in your area.

STORAGE:

Metalock DTM High Build Primer and **Metallock Hardener** should be stored in a cool, dry place with adequate ventilation away from heat, sparks and flames. The shelf life for **Metallock DTM High Build Primer** and **Metallock Hardener** is 3 years when stored under normal conditions.

RELATED PRODUCTS:

Part:	Product Name:	Size:
38351	Plastic & Leather Prep	Gallon
38353	Plastic & Leather Prep	16 oz. Aerosol
38354	Plastic & Leather Prep	Quart
38371	SEM Solve	Gallon
38373	SEM Solve	20 oz. Aerosol
38374	SEM Solve	Quart
38375	SEM Solve	5 Gallon
38391	Scuff & Clean	Gallon
38398	Scuff & Clean	16 oz. Tube
77771	XXX Universal Surface Cleaner	Gallon
77774	XXX Universal Surface Cleaner	Quart



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Technical Consultation Service

Our Technical Staff is ready to assist you with any questions. You are invited to take advantage of our extensive experience, laboratory services and trained field service representatives. Call (800) 831-1122 for answers to your questions. Hours of operation are Monday through Thursday 8:00 am until 5:00 pm EST and on Friday 8:00 am until 4:30 pm EST.

Disclaimer:

The information supplied in this document is for guidance only and should not be construed as a warranty. All implied warranties are expressly disclaimed. All users of the materials are responsible for assuring that it is suitable for their needs, environment and use. All data subject to change as SEM deems appropriate.

Users should review the Safety Data Sheet (SDS) and product label for the material to determine possible health hazards, appropriate engineering controls and precautions to be observed in using the material. Copies of the SDS and product label are available upon request.